



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2571
Job Sheet 190784

Part No: D2571 **Job Qty:** 12 pcs
Part Name: Saddle, Fwd, Out

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 2/14/19 **Job Tracking No:**
Due Date: 3/18/19 **Created By:** Marie Lajeunesse
Type: ~~Stock~~ **SOLD** **Description:**
Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	3/18/19		0.57	19.35	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SB 19/4/22
							HAAS - 4		
110	Conventional Mill - 1 - B4B	12 pcs	3/18/19		0.00	1.85	Conventional Mill - 1 - B4B		UHS 19/4/22
							Conventional Mill - 2 - B4B		
120	QC 2	12 pcs	3/18/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		UHS 19/4/22
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
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Container No: S172277



Part: D2571
Job No: 190784
Serial No/Batch: S172277
Revision:
Inspector:
Exp Date:
Instructions: Various STC's **Date:** 04/15/19

130 QC 8	12 pcs	3/18/19	0.00	0.00	QC 2 - 56	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
140 Handfinish - 1-1 Chemical- B4B	12 pcs	3/18/19	0.00	0.40	QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	D.R. 19/04/25
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R. 19/04/25
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	

[illegible]

						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
180	QC 21 - SA	12 pcs	3/18/19	0.00	0.00	QC 21 - SA - 21	546
						QC 21 - SA - 70	27
						QC 21 - SA - 53	79
							MAY 01 2019

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. _____ Double check by: _____ 1-Machine Step No 1
Descriptions: per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per
attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect
110 - (Manufacture as per dwg) Machine keyway as per dwg D2571 & D2572
120 - (QC2- Inspect parts off machine FAI/FAIB) Inspect on CMM as per folio CMM022.
130 - (QC8- Inspect parts - second check)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	12 pcs (1 ea)	100-HAAS 4 Axis	5 1066702

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-007	12	33	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Outboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Fwd Outboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Fwd Outboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Fwd Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
10	Saddle, Fwd Outboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
11	Saddle, Fwd Outboard	0.558Inches + 0.020 - 0.000	0.578 0.558		
12	Saddle, Fwd Outboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
13	Saddle, Fwd Outboard	1.490Inches + 0.010 - 0.000	1.500 1.490		
14	Saddle, Fwd Outboard	2.495Inches + 0.010 - 0.000	2.505 2.495		
15	Saddle, Fwd Outboard	3.869Inches + 0.010 - 0.000	3.879 3.869		
16	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
17	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
18	Saddle, Fwd Outboard	0.240Inches + 0.020	0.260		

			- 0.000	0.240
19	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Outboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Fwd Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Outboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

Plex 2/14/19 1:39 PM Dart.lajeunesse.marie

md 20 jan 2019

Entered: 19/17/4 Date:

NCR No. 19-7207

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: 190784 Part No. D2571		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: 19/4/17	Sequence #: 100	QTY Affected: 1		MRB (QS1042) PD 19-04-25			
Description Work Order Deviation Offset of ballmill was not setted correctly on 3 rd operation 03001				Disposition Scrap replace Batch # S172277			
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☒	
Completed By		Lead hand / Supervisor De 19-04-18					
QC / QA Coordinator DAS 68 9-89 APR 25 2019							

DART AEROSPACE LTD		Work Order:	190 784
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.749	1.750		
C	3.495	3.505		3.500	3.500	3.498	3.500		
D	1.745	1.755		1.750	1.750	1.748	1.750		
E	7.990	8.010		7.999	7.998	7.998	7.998		
F	0.490	0.510		0.503	0.500	0.5035	0.499		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.5075	0.500	0.500	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.576	0.568	0.570	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.125	0.120	0.130	0.125		
Q	0.115	0.135		0.125	0.125	0.124	0.124		
R	0.240	0.260		0.251	0.250	0.250	0.250		
S	0.115	0.135		0.135	0.135	0.135	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.240	0.241	0.231		
W	0.115	0.135		0.125	0.128	0.124	0.125		
X	0.308	0.313		0.312	0.311	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.365	0.364	0.3653		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.625	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.062	0.071		
AD	0.240	0.260		0.249	0.251	0.251	0.242		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.130	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.260	0.245	0.251	0.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:		Audited by:	
Date:	19/4/16	Date:	19/04/25

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	190 784
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	# 5	# 6	# 7	# 8		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.999	7.999		
F	0.490	0.510		0.503	0.501	0.502	0.504		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.505	0.5065	0.502	0.5005		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.572	0.5705	0.568	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.128	0.135	0.135	0.135		
Q	0.115	0.135		0.124	0.125	0.124	0.125		
R	0.240	0.260		0.251	0.252	0.252	0.252		
S	0.115	0.135		0.131	0.135	0.134	0.135		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.244	0.237	0.238		
W	0.115	0.135		0.120	0.125	0.125	0.125		
X	0.308	0.313		0.312	0.311	0.312	0.3115		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.365	0.361	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.627	0.625		
AC	0.053	0.073		0.065	0.061	0.064	0.063		
AD	0.240	0.260		0.250	0.252	0.247	0.247		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.138	0.130	0.138		
AG	0.240	0.280		0.250	0.250	0.247	0.250		
AH	0.240	0.260		0.251	0.250	0.240	0.240		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:		Audited by:	mm
Date:		Date:	19/09/25

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 191784
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.995	7.998	8.000	7.992		
F	0.490	0.510		0.502	0.503	0.500	0.495		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.502	0.5025	0.5025	0.5025		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.126	0.126	0.125	0.123		
R	0.240	0.260		0.252	0.252	0.252	0.251		
S	0.115	0.135		0.134	0.130	0.134	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.233	0.242	0.244		
W	0.115	0.135		0.128	0.120	0.123	0.123		
X	0.308	0.313		0.315	0.319	0.312	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.367	0.367	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.628	0.629	0.627		
AC	0.053	0.073		0.066	0.063	0.065	0.065		
AD	0.240	0.260		0.247	0.243	0.2515	0.254		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.250	0.250	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:		Audited by:	10/04/25
Date:		Date:	10/04/25

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	